

Work Order ID 57612

Friday, April 09, 2010 2:45:57 PM



Page 1

Item ID: D4021-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Blanking Plate

Start Date: 4/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: umf Date: 10-4-9 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4021

Rev B

Pho →

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: A

Dwg Rev: A

304 1003

Deburr as required

B 10-4-12

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-4-12

Dart Aerospace Ltd

W/O: 57612		perm change						WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/4/15	#100	Heads on box should be @ Rev B.				AA	10.04.20			S 10/04/15	

Part No: D4021-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57612

Friday, April 09, 2010 2:45:57 PM

Page 2

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Item Name: Blanking Plate

Start Date: 4/12/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 4/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/6/15

(X8)

Ph →



QC

Memo

Quality Control

140

Identify as per dwg & Stock Location: 109

0.00



Packaging

Memo

Packaging

R10/4/20 (8)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/6/20 JF

mf

10-4-20

Dart Aerospace Ltd

W/O: 57612		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/05	#121	Perm. Change Due to New B ¹¹ Day. + Powder coat per AS1005 white M14207 Start time 11:00AM Fin time 11:30AM temp 400°C	J	10/04/19	8		8 10/04/15
	122	QC3 inspect Powder coating	BR	10-06-19	8		8 10/04/15

Part No: D4021-S PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 09, 2010 2:45:56 PM

Page 1

Work Order ID: 57612



Parent Item: D4021-5



Parent Item Name: Blanking Plate

Start Date: 4/12/2010



Required Date: 4/13/2010

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per dwg

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	17.1000	0.3928	53		
												
304/316 Sheet .063											113 10-4-12	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

113295

17.1

17.1

113295

8

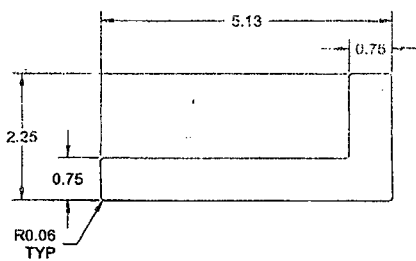
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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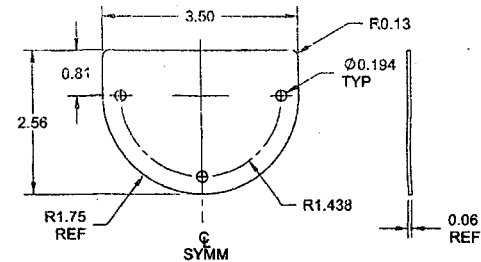
NOTE: Date & initial all entries



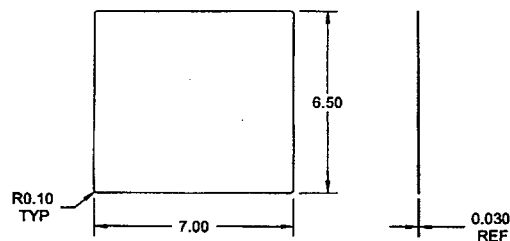
D4021-1 HANDLE PLATE



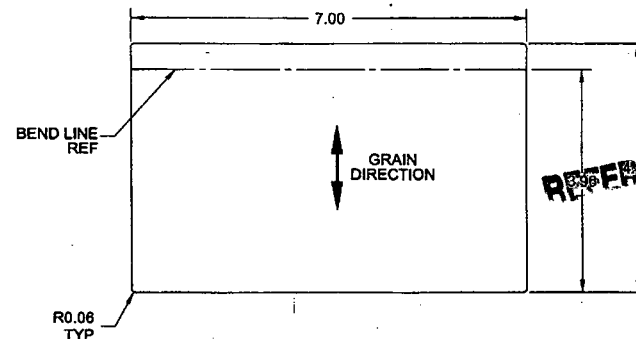
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE






D4021-3F DATA PLATE
FLAT PATTERN

REFERENCE ONLY

RELEASED
2010-04-14
NIP

- NOTES:**
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
 - 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
 - 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH:** -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS:** INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX
- 6) IDENTIFICATION:** N/A
- 7) WEIGHT:** -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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